

Work Order ID 158815

Friday, March 31, 2017 7:23:25 PM

158815

Page 1

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Fwd, Out
Start Date: 3/31/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED
Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	F								DAS 14 9-89 17/04/06 DAS 44 9-89 17-04-04
100	HAAS CNC VERTICAL MACHINING #1	3.70							
100									
HAAS 1	Memo	5.11							
HAAS CNC vertical machine #1	Program Batch No. <u>158815</u>								
	Double check by: <u>OK</u>								
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets								
	2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets								
	3-Machine Step No 3 per Folio FA051 and inspect								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	2.40							
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572								

Friday, March 31, 2017 7:23:25 PM

Page 2

[illegible]

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Friday, March 31, 2017 7:23:25 PM

158815

Page 3

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Start Date: 3/31/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>n 136657</i> Memo START TIME: <i>8:20</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>8:50</i>	0.00 0.84				<i>12</i>	<i>0</i>	<i>1704-20</i>	<i>33</i> <i>9:45</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.12				<i>12</i>			<i>DAS</i> <i>38</i> <i>9:55</i> <i>APR 20 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST 397</i> Memo	0.00 0.12				<i>12x</i>		<i>50174-24</i>	

Work Order ID 158815

Friday, March 31, 2017 7:23:25 PM

158815

Page 4

Item ID: D2571 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle, Fwd, Out
Start Date: 3/31/2017 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 12.00 *12* Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.20							
Quality Control									

DAS
21
9-89

APR 27 2017

Picklist Print

Friday, March 31, 2017 7:23:25 PM

Work Order ID: 158815

158815

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 3/31/2017

Required Date: 4/12/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	24.0000	1	12			
D6101-007									**				
Saddle Billet													

DAS
44
9-89 17-04-04

Location

Loc Qty

Loc Code

MAT041

24

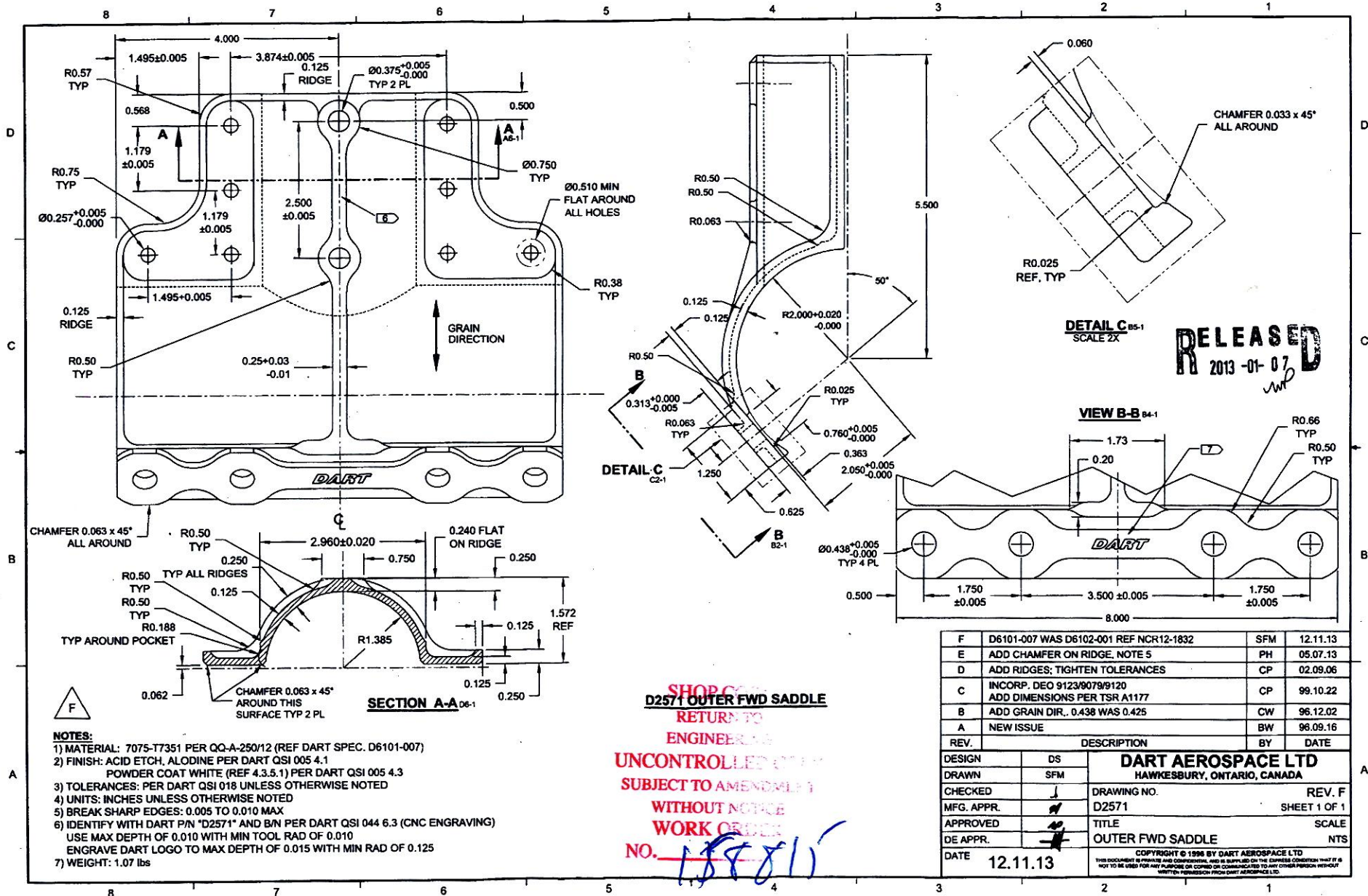
154453

4

156737

20

12



DART AEROSPACE LTD		Work Order: 118815	
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.998		
F	0.490	0.510		.499	.496	.502	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.498	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.566	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.124	.124	.125	.124		
R	0.240	0.260		.252	.251	.251	.251		
S	0.115	0.135		.125	.131	.128	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		.240	.236	.238	.237		
W	0.115	0.135		.119	.119	.119	.118		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.366	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.250	.250		
AE	1.375	1.395		1.389	1.385	1.385	1.385		
AF	0.115	0.135		.125	.130	.130	.130		
AG	0.240	0.280		.265	.265	.260	.265		
AH	0.240	0.260		.249	.247	.247	.247		
AI	2.000	2.020		2.004	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

DAS

49

Measured by:	44	14
Date:	17-04-04	17/04/04

Audited by:	9-89
Date:	17/04/04

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 152815
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	27	48		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		.500	.500	.497	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.499	.499	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.567	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.125	.124	.125	.125		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.125	.124	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.237	.236	.238		
W	0.115	0.135		.118	.119	.119	.120		
X	0.308	0.313		.311	.311	.311	.309		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.362	.361	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.247	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.246	.247	.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.063		

Accept/Reject **DAS**

DAS

Measured by:	14
Date:	9-89 17/04/06

Audited by:	49
Date:	9-89 17/04/09

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 158815
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	311	412		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.124	.124	.125	.124		
R	0.240	0.260		.252	.253	.252	.252		
S	0.115	0.135		.129	.128	.130	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.966		
V	0.230	0.250		.239	.238	.238	.237		
W	0.115	0.135		.121	.120	.119	.118		
X	0.308	0.313		.310	.311	.311	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.362	.363	.363	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.624	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.249	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.266	.266		
AH	0.240	0.260		.249	.249	.249	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject **bas**

Measured by: 14	Audited by: DAS
Date: 17/04/06	Date: 49 17/04/09

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	